



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4812-041
Job Sheet 169432



Part No: D4812-041

Job Qty: 1 ea

Part Name: Patient Stop Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/14/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP REV:B 16.04.19 AS PER DWG REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/13/17	0.00	0.00	Start Up Waterjet		a 17/12/12
100	Waterjet	1 pcs		12/13/17	0.00	0.27	Waterjet1		a 17/12/12
110	QC	1 pcs		12/13/17	0.00	0.00	QC2 Waterjet-1		a 17/12/12
120	QC	1 pcs		12/13/17	0.00	0.00	QC8-5		38
130	Small Fab	1 pcs		12/13/17	0.08	0.27	Small Fab-7		DAS 9-89
140	QC	1 pcs		12/13/17	0.00	0.00	QC5		38
150	HandFinish	1 pcs		12/13/17	0.00	0.12	HandFinish1		B 17/12/15
160	QC	1 pcs		12/13/17	0.00	0.00	QC7-4		BK 17-12-15
170	Powdercoat	1 pcs		12/13/17	0.00	0.08	Powdercoat1		BK 17-12-15
180	QC	1 pcs		12/13/17	0.00	0.00	QC3		38
190	Small Fab	1 pcs		12/14/17	0.00	0.27	Small Fab-7		FF 9-89
200	QC	1 pcs		12/14/17	0.00	0.00	QC5		38
210	Packaging	1 pcs		12/14/17	0.00	0.00	Packaging3-2		38
220	QC21-SA	1 Ea		12/14/17	0.00	0.00	QC21		38

M 138467

START 0.25

QUIT 1300

FINISH 10.55

DAS 21

DEC 18 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063	2	391	0	0
190-Small Fab	D2690-6 5012261	2	93	0	0
	D4811-1 7165250	2	11	0	0
	MS21042L3 5006901	2	4,398	0	0
	MS27039-1-07 711384092	2	81	0	0
	NAS1149D0332J 5020606	6	27	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skic _____ Mac _____ Thermofo _____ Larg _____		Verifying ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY _____		2) Approval _____ eted By _____ / Supervisor _____ /erification _____ oordinator _____ roval _____ id Wrong _____ Dimensions _____ der tolerance _____ rrect _____ /Missing _____ red _____ Sequence _____					
Description Work Order Deviation 				Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				Mfg Date: 12/13/17 Job No: 169432			
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Darr ☐ Inspection Ir ☐ Contaminati ☐ Countersink ☐ Cut Too Sho ☐ Instructions ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Darr ☐ Inspection Ir ☐ Contaminati ☐ Countersink ☐ Cut Too Sho ☐ Instructions ☐ Drill Holes ☐	 S021431 Patient Stop Assembly		PART NO: D4812-041 Revision: Start up Operation Operation: Start up Operation Change No:	
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OTHER : _____				PART NO: D4812-041 Revision: Start up Operation Operation: Start up Operation Change No:							

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	
B	16.06.24	Dwg Rev updated	KJ	